

Work Order ID 63156

Thursday, October 21, 2010 3:55:19 PM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop



Start Date: 10/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/10/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

0.00

8/10/10/02

[Signature] for BG 10-10-29 @

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

10/10/10/20

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8/10/11/02

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Accept



Setup Start



Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop



Start Date: 10/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011 , Location: <u>20</u> PPP Rev: <u>C</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

01/11/03 22

CK 10/11/03

mf
10-11-2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

54.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST328

54

113064

3

113749

1

114056

50

AN526C832R8

Purchased

No

120

Each

164.0000

8

16



Screw

Location

Loc Qty

Loc Code

ST327

164

114615

64

114718

100

AN526C832R9

Purchased

No

120

Each

202.0000

8

16



Screw

Location

Loc Qty

Loc Code

ST327

202

115422

3

115835

99

115936

100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD10 NAS1149D0363J Purchased No

120 Each

8.0000

4 8

Washer

M115022 10/1/10

Location

Loc Qty

Loc Code

ST 6

107715 6

ST335 2

105792 2

AN960JD8 NAS1149DN832 Purchased No

120 Each

10.0000

24 48

Washer

M115096 10/1/10

Location

Loc Qty

Loc Code

ST347 10

105059 10

D2143 Manufactured No

120 Each

14.0000

1 2

Hinge Bracket

10/1/10

Location

Loc Qty

Loc Code

ST198 14

55323 14

D2144 Manufactured No

120 Each

39.0000

1 2

Hinge Bracket

10/1/10 (2)

Location

Loc Qty

Loc Code

ST198 39

55179 39

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

S-2 D2150
Packer Doubler, Hinge

Manufactured No

120 Each

28.0000

2 4

Location

Loc Qty

Loc Code

ST007

28

55178

28

S-2 D2151
Packer Doubler, Hinge

Manufactured No

120 Each

51.0000

2 4

Location

Loc Qty

Loc Code

ST007

51

55319

13

62246

38

S-2 D2153
Door Prop

Manufactured No

120 Each

20.0000

1 2

Location

Loc Qty

Loc Code

ST272

20

59818

20

S-2 D2154
Stud Bracket

Manufactured No

120 Each

7.0000

1 2

Location

Loc Qty

Loc Code

ST007

7

55325

7

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2237

Manufactured No

120

Each

66.0000

2

4



Striker Plate

Location

Loc Qty

Loc Code

ST009

19

60492

19

ST010

47

62212

47

D2461

Manufactured No

120

f

145.9772

7.25

15.26316



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

145.9772105

39782

6.5

55054

139.477211

cut 1 X 87.00"

D2463

Manufactured No

120

f

508.9300

7.25

15.26316



Seal

Location

Loc Qty

Loc Code

ST404

508.93

55561

8.93

62597

500

cut 1 X 87.00"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2583

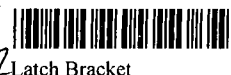
Manufactured No

120 Each

24.0000

2

4



Latch Bracket

Location

Loc Qty

Loc Code

ST017

22

~~61715~~

22

ST018

2

56527

2

D2585

Manufactured No

120 Each

32.0000

2

4



Mounting Channel

Location

Loc Qty

Loc Code

ST019

32

56524

1

59118

5

59873

26

D2586

Manufactured No

120 Each

67.0000

2

4



Door Latch

Location

Loc Qty

Loc Code

ST006

7

~~57917~~

7

ST204

60

61655

60

D2587

Manufactured No

120 Each

17.0000

1

2



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST019

17

56555

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2589
Keys, Key Chain, 350 Hinge

Manufactured No

120 Each

167.0000

1

12/11/10

Location

Loc Qty

Loc Code

ST019

167

58194

167

D2690-17
Cable

Manufactured No

120 Each

20.0000

1

12/11/10

Location

Loc Qty

Loc Code

ST021

20

62480

20

D2857-1
Hinge Bracket

Manufactured No

120 Each

32.0000

1

12/11/10

Location

Loc Qty

Loc Code

ST026

32

56529

9

57924

23

D2857-2
Hinge Bracket

Manufactured No

120 Each

36.0000

1

12/11/10

Location

Loc Qty

Loc Code

ST027

36

55020

1

56530

11

57925

24

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2858-1 Manufactured No

120 Each

19.0000



Hinge Bracket

1 2
10/11/10

Location

Loc Qty

Loc Code

ST027

19

56423

13

61522

6

2

D2858-2 Manufactured No

120 Each

11.0000



Hinge Bracket

1 2
10/11/10

Location

Loc Qty

Loc Code

ST027

11

56048

5

61523

6

2

FG-778150-550-ROL Purchased No

120 sf

1,863.750



7781 9oz Glass 50"x125yd

1 2
10/11/10

Location

Loc Qty

Loc Code

ST404

1863.75

108932

18

111166

399

113905

1446.75

2

1- cut 1 square ft of glass cloth

MS20426AD3-4 Purchased No

120 Each

6,064.000



RIVET

12 24
10/11/10

Location

Loc Qty

Loc Code

ST316

6064

104374

2064

110398

4000

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63156

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

120

Each

715.0000

18



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

650

114761

650

ST319

65

111916

65

MS21042L08

Purchased

No

120

Each

250.0000

18



Nut

Location

Loc Qty

Loc Code

ST300

250

115300

50

115835

200

MS21042L3

Purchased

No

120

Each

2,338.000

4



Nut

Location

Loc Qty

Loc Code

ST300

2338

114523

49

114784

1289

115835

1000

MS27039-08-11

Purchased

No

120

Each

53.0000

2



Screw

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST290

3

113749

3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63156



Parent Item: D350-588-011



Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-15

Purchased

No

120

Each

61.0000

2

4



10/11/10 af 20

Screw

Location

Loc Qty

Loc Code

ST292

61

114056

2

114718

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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